

Work Order ID 144912

April 27, 2016 1:10:35 PM

144912*Bel*

Page 1

Item ID: D3574-6 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Cabin Floor Protector
Start Date: 4/28/2016 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 5/10/2016 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: *dm* *SH* Date: *16/04/27* Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3574	Rev B								

100

0.00

100

FLOW WATER JET

Waterjet

Memo

1.36

FLOW CNC Waterjet

1-Cut as per Dwg D3574

Dwg Rev: *B*Prog Rev: *B*

2-Deburr

4 *16-4-29/16/18*

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.04

Quality Control

4 *16-4-29/16/18*

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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April 27, 2016 1:10:35 PM

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Page 2

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 Required Date: 5/10/2016 Req'd Qty: 4.00 ***4*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00				(4)			38 9-89
120									
QC	Memo	0.08							
Quality Control									

MAY 02 2016

130	Small Fab	0.00							
130									
Small Fab	Memo	0.00							
Small Fab	Deburr if necessary.	0.00							

N/A

140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									

N/A

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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April 27, 2016 1:10:35 PM

144912

Page 3

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Revision ID: Stop ***NS2***
Item Name: Cabin Floor Protector
Start Date: 4/28/2016 Start Qty: 4.00 ***4*** Cust Item ID:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <i>PK</i>	0.00				<i>DAS</i>			
150						<i>6</i>			
Packaging	Memo	0.04				<i>9-69</i>			<i>APR 27 2016</i>
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.40				<i>MLJ</i>			<i>MAY 03 2016</i>
Quality Control									

MLJ *MAY 03 2016*

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
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OTHER : ☐					

Picklist Print

April 27, 2016 1:10:38 PM

Page 1

Work Order ID: 144912

144912

Parent Item: D3574-6

D3574-6

Parent Item Name: Cabin Floor Protector

Start Date: 4/28/2016

Required Date: 5/10/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev :A New Issue 07.07.23 EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No				sf	1,895.693		101.4118			
MI FXS 125-F60029-04									**	<u>16-4-29</u>			
GE PLASTICS LEXAN SHEET													

Location

Loc Qty

Loc Code

MAT018

1895.693

m133111

353.893

m134389

1541.8

128

DART AEROSPACE LTD		Work Order:	144912
Description: Cabin Floor Protector		Part Number:	D3574-6
Inspection Dwg: D3574 Rev: B		Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	3.010	-		DCO2	
7.37	+/-0.030	7.37	-			
11.00	+/-0.030	11.00	-			
15.25	+/-0.030	15.25	-			
25.87	+/-0.030	25.87	-			
39.75	+/-0.030	39.75	-			
44.75	+/-0.030	44.75	-			
58.38	+/-0.030	58.38	-			
63.50	+/-0.030	63.50	-			
65.25	+/-0.030	65.25	-			
10.25	+/-0.030	10.25	-			
11.87	+/-0.030	11.87	-			
14.75	+/-0.030	14.75	-			
26.00	+/-0.030	26.00	-			
40.87	+/-0.030	40.87	-			
45.00	+/-0.030	45.0	-			
48.00	+/-0.030	48.0	-			
55.13	+/-0.030	55.13	-			
61.25	+/-0.030	61.25	-			
61.88	+/-0.030	61.88	-			
64.63	+/-0.030	64.63	-			
1.13	+/-0.030	1.13	-			
7.63	+/-0.030	7.63	-			
11.00	+/-0.030	11.0	-			
22.10	+/-0.030	22.1	-			
22.50	+/-0.030	22.5	-			
24.50	+/-0.030	24.5	-			
35.13	+/-0.030	35.13	-			
36.50	+/-0.030	36.5	-			
40.00	+/-0.030	40.0	-			
41.88	+/-0.030	41.88	-			
43.63	+/-0.030	43.63	-			
6.75	+/-0.030	6.75	-			
9.50	+/-0.030	9.5	-			

DART AEROSPACE LTD		Work Order:	144912
Description: Cabin Floor Protector		Part Number:	D3574-6
Inspection Dwg: D3574 Rev: B		Page 2 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

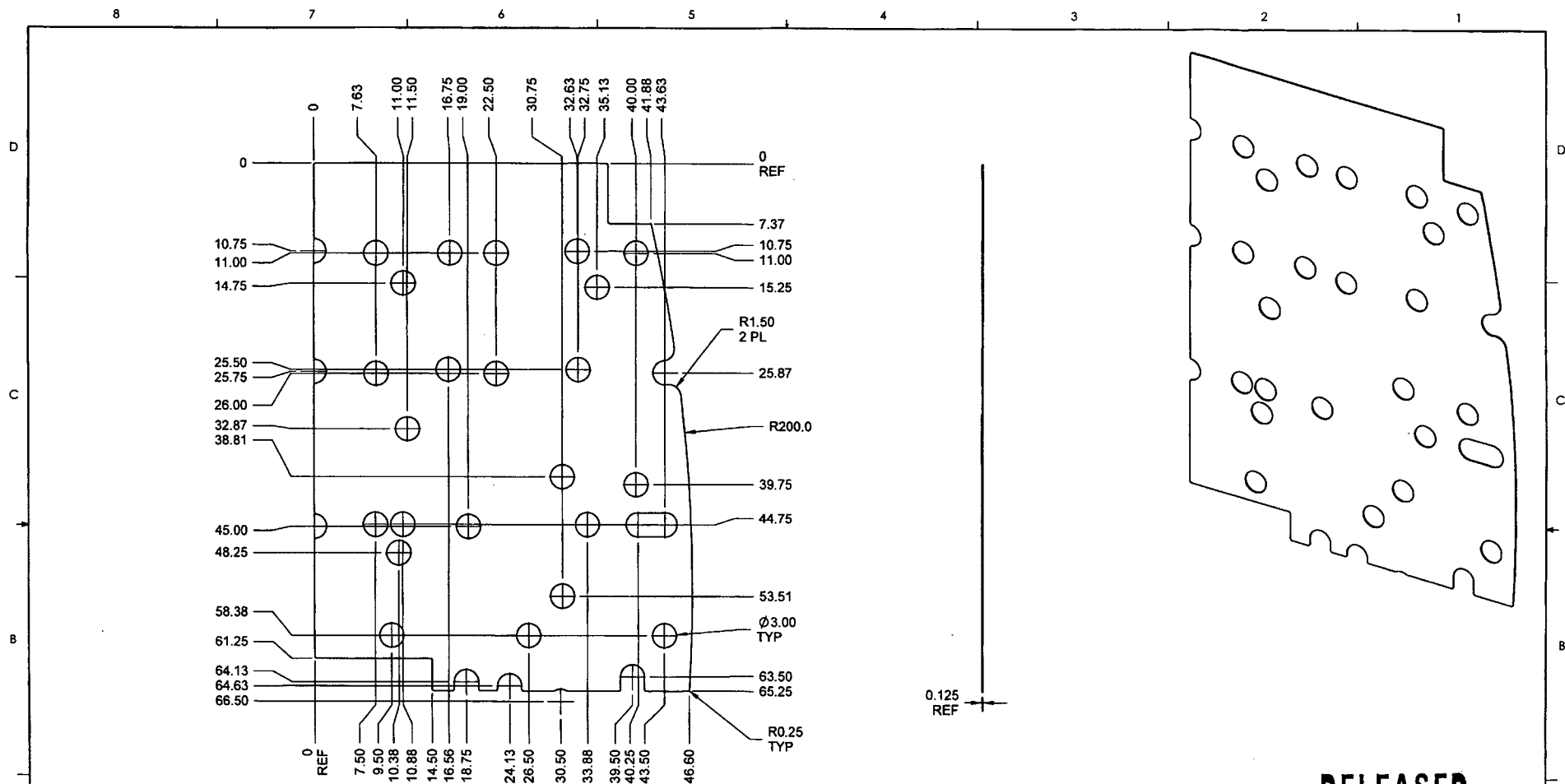
☒ **First Article**

 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.38	+/-0.030	10.38	-		DC62	
14.50	+/-0.030	14.50	-			
16.75	+/-0.030	16.75	-			
18.94	+/-0.030	18.94	-			
19.00	+/-0.030	19.00	-			
24.13	+/-0.030	24.13	-			
33.88	+/-0.030	33.88	-			
39.50	+/-0.030	39.50	-			
40.25	+/-0.030	40.25	-			
43.50	+/-0.030	43.5	-			
46.60	+/-0.030	46.60	-			
0.125	+/-0.010	0.125	-			

Measured by: <i>JK/SS</i> Date: 16-4-29	Audited by: ^{DAS} 38 Date: MAY 02 2016	Prototype Approval: N/A Date: N/A
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Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/DD	
B	09.05.15	Dimensions updated per Dwg Rev B	KJ <i>JK</i>	<i>SS</i>



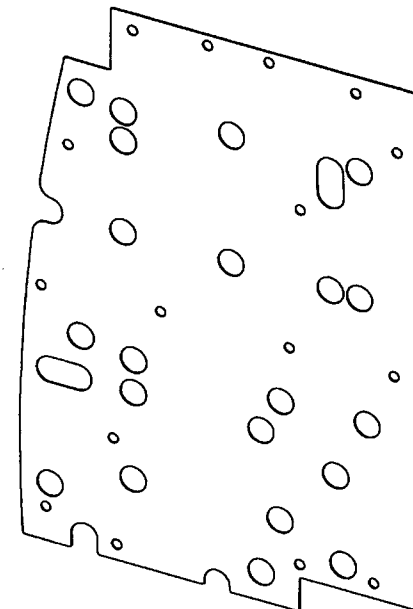
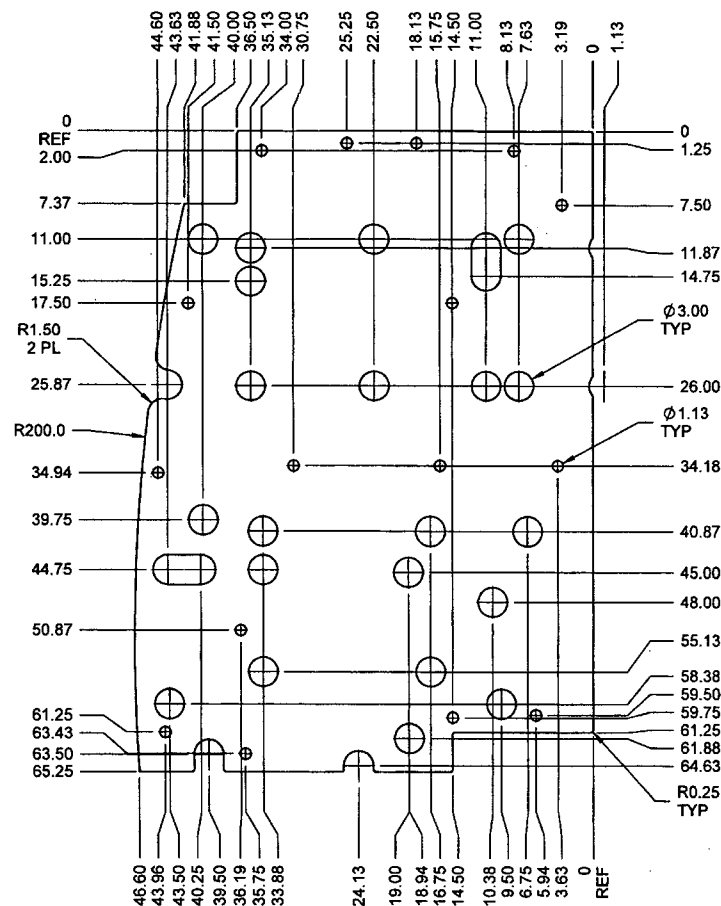
D3574-2 CABIN FLOOR PROTECTOR

RELEASED
09/04/07

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-2" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.30 lbs
- 8) CHECK PER TEMPLATE DT8961

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3574	REV. B
MFG. APPR.			SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		CABIN FLOOR PROTECTOR	NTS
DATE	09.03.25	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



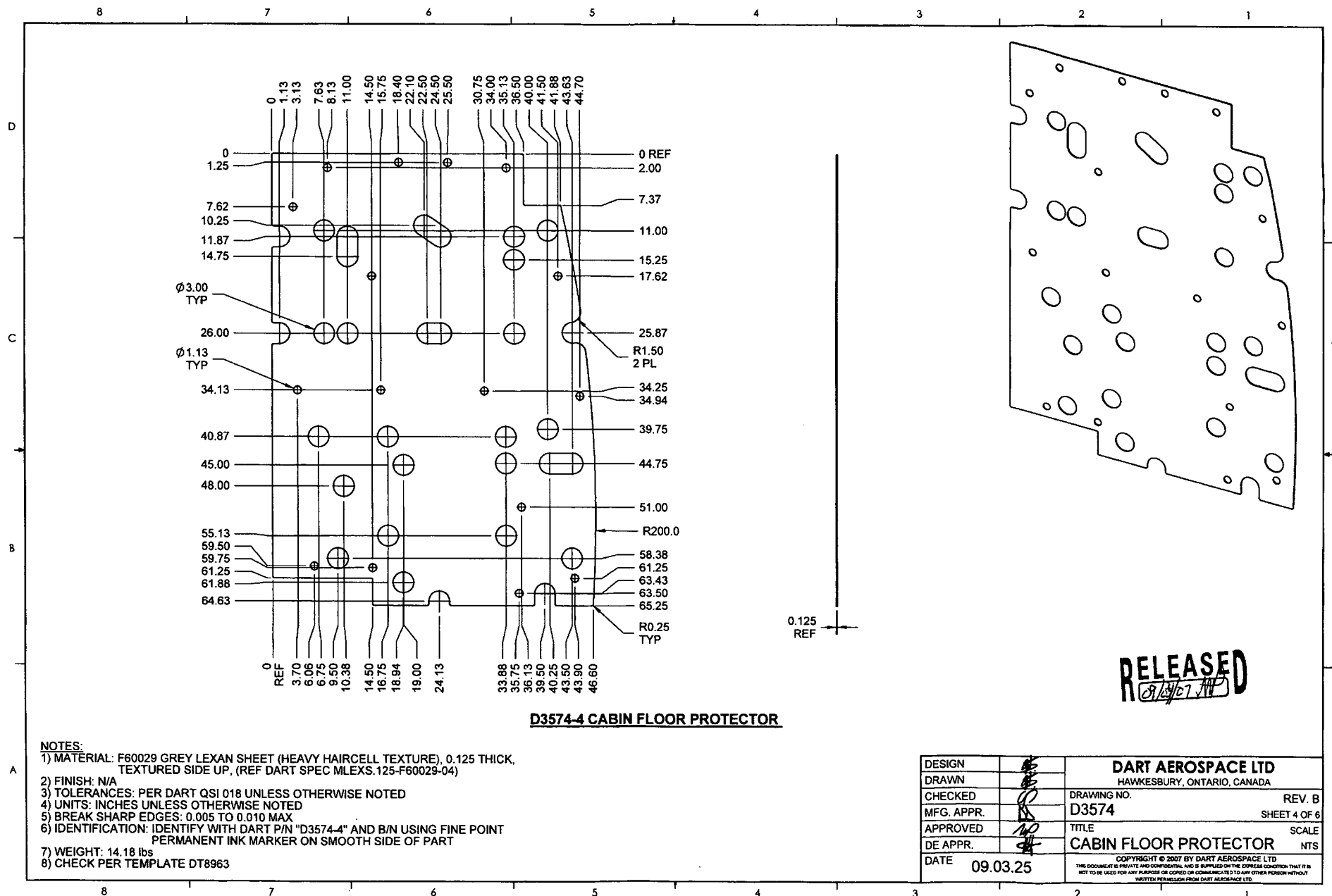
D3574-3 CABIN FLOOR PROTECTOR

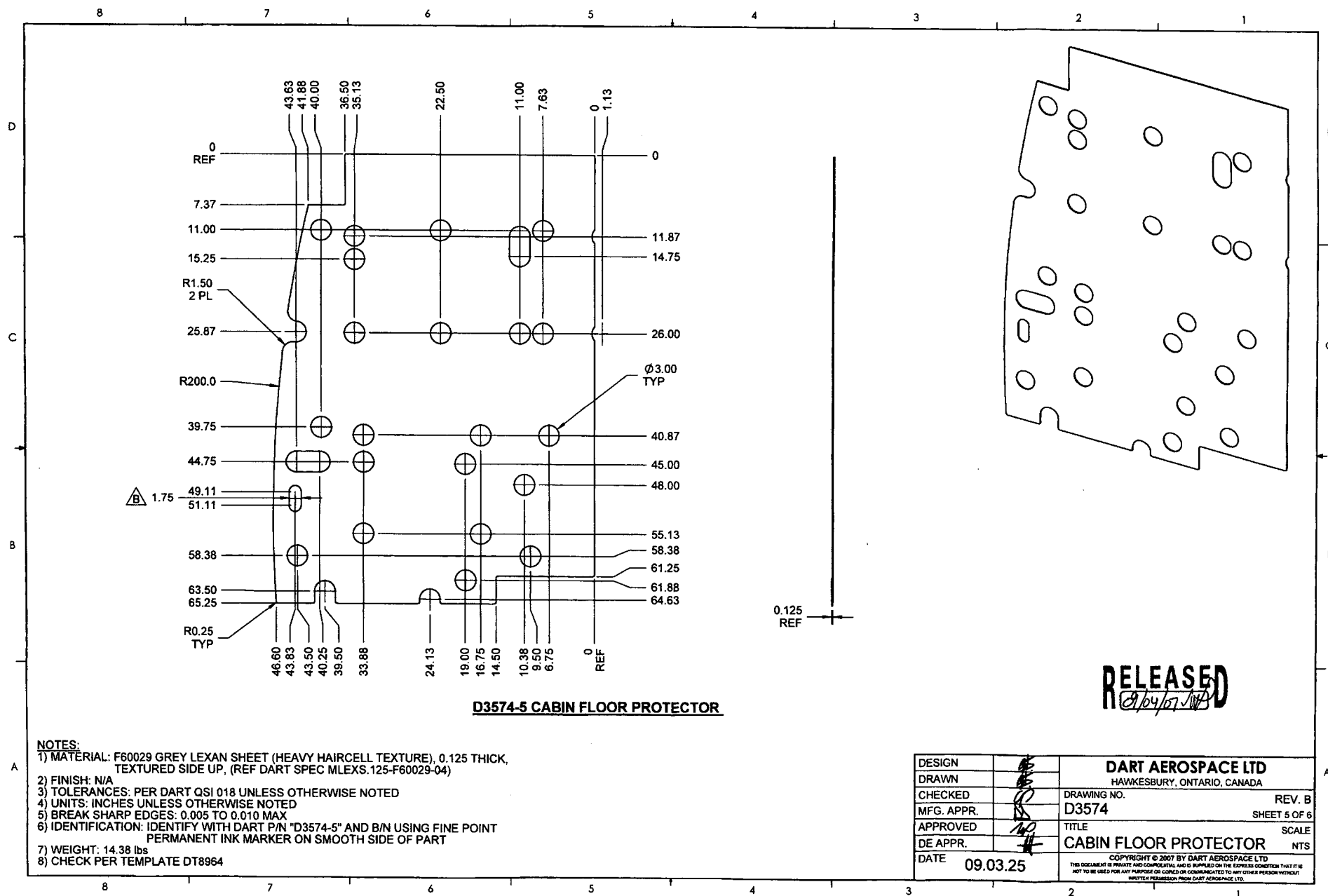
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- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-3" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.33 lbs
- 8) CHECK PER TEMPLATE DT8962

RELEASED
01/16/07

DESIGN	JS	DART AEROSPACE LTD	
DRAWN	JS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. B
MFG. APPR.	JS	D3574	SHEET 3 OF 6
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	CABIN FLOOR PROTECTOR	NTS
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RELEASED
09/04/07

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-5" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.38 lbs
- 8) CHECK PER TEMPLATE DT8964

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3574	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		CABIN FLOOR PROTECTOR	NTS
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